

Work Order ID 84387

May-11-12 8:16:16 AM

84387

Page 1

Item ID: D3152-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 11/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 25/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/11

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3152	Rev B

100 0.00

100 FLOW WATER JET

Waterjet

Memo

0.00

4 0 JM 12-6-15

FLOW CNC Waterjet
2624 .063
1-Cut as per Dwg
Dwg Rev: B
Prog Rev: B
2-Deburr if necessary

110 0.00

110 QC

Quality Control

Memo

0.00

4 0 JM 12-6-15

120 0.00

120 QC

Quality Control

Memo

0.00

57 locs

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

130

130

Brake NC

Brake NC

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

4

SD
13/02/12

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

SMF
B.221

4

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

4 B.225

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

QC

Quality Control

QC7-Inspect Chemical Conversion Coat

0.00

170

170

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

4 ✓

180

180

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

4

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Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: STO30 0.00

190

Packaging

Packaging

Memo

0.00

AA

SP
13-2-27

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Quality Control

Memo

0.00

13/2/28 AF

MLJ 13-02-28

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NOTE: Date & initial all entries

Picklist Print

May-11-12 8:16:19 AM

Page 1

Work Order ID: 84387

84387
D3152-2

Parent Item: D3152-2

Parent Item Name: Bracket

Start Date: 11/05/2012

Required Date: 25/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.05.10 DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	376.3800	0.04	0.168421			

M2024T3S 063

2024-T3 .063 sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	376.38	
119916	141.38	
121197	235	

117392

117392

Jm 12-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	84397
Description: Bracelet	Part Number:	03152-2
Inspection Dwg: 03152 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

President

Measured by:	Jm	Audited by:	S	Preliminary Approval:	
Date:	12-6-15	Date:	12/06/15	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



SHOP COPY
DESIGN

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3152 REV. B SHEET 1 OF 2
DATE		TITLE SCALE 04.10.18 BRACKET ASSEMBLY 1:1

RELEASED
04.11.23

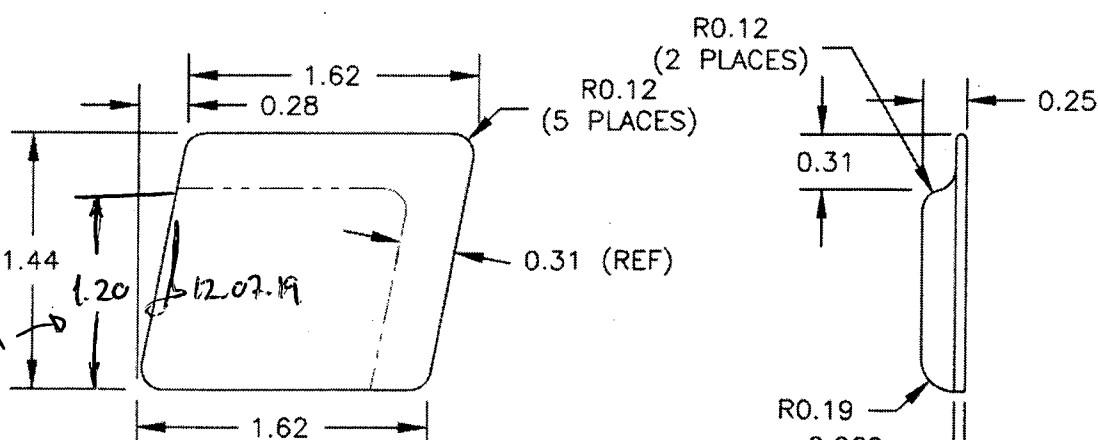
D3152-041 BRACKET ASSEMBLY
D3152-042 BRACKET ASSEMBLY

IDENTIFY WITH DART P/N
USING FINE POINT PERMANENT
INK MARKER

D3152-3 (-041)
or D3152-4 (-042)

BOND D3152-3/-4(OPP) SEAL TO
D3152-1/-2(OPP) BRKT USING
RTV 732 CLEAR (A/R)
OR RTV 732 BLACK (A/R)

D3152-1 (-041)
or D3152-2 (-042)



D3152-3 SEAL (SHOWN)

D3152-4 SEAL (OPPOSITE)

1. D3152-3 REPLACES PREMIER P/N B30-23000-243
2. D3152-4 REPLACES PREMIER P/N B30-23000-244
3. MAKE D3152-3 PER TOOL # B30-23000-243T
4. MAKE D3152-4 PER TOOL # B30-23000-244T
5. MATERIAL: RTV 732 BLACK
6. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7. ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 87387MCJ
12/05/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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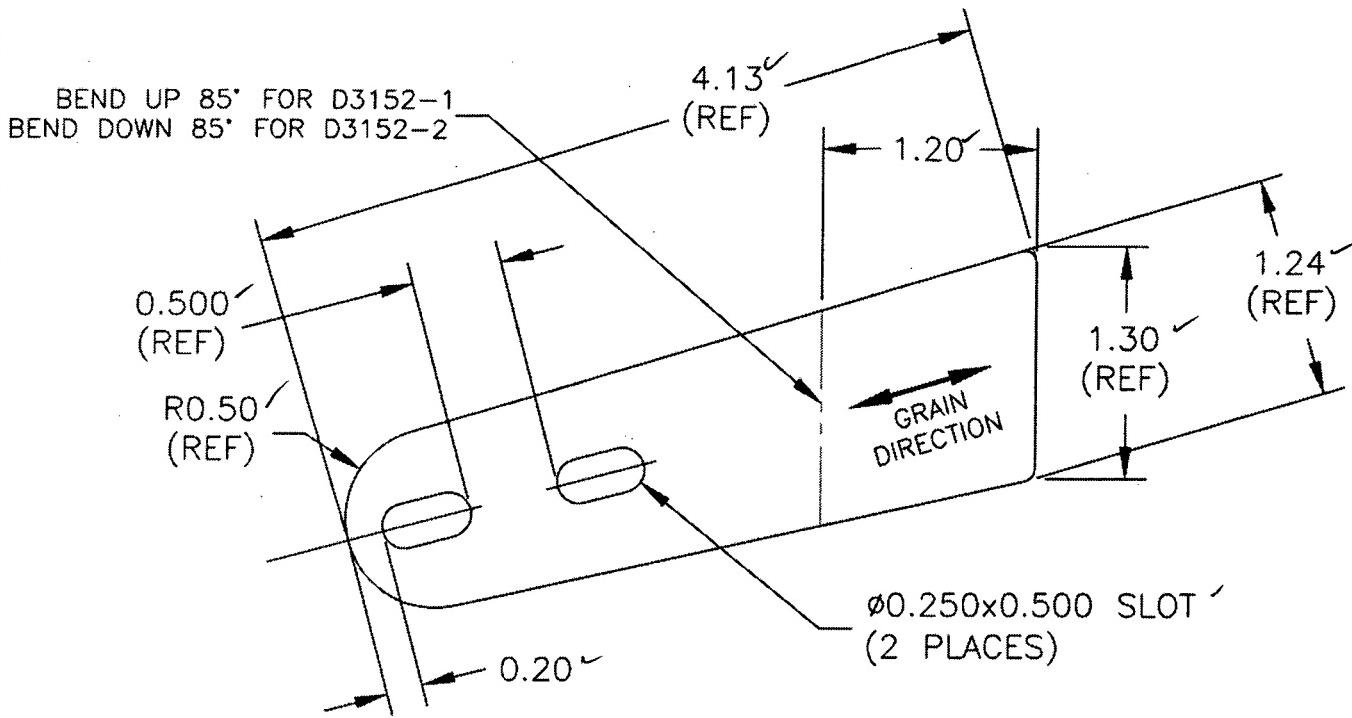
NOTE: Date & initial all entries



OR COPY IS
PERMITTED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3152	SHEET 2 OF 2
DATE	TITLE	SCALE	
04.10.18	BRACKET ASSEMBLY	1:1	

RELEASED
04.11.23



D3152-1/-2 BRACKET

1. D3152-1 REPLACES PREMIER P/N B30-23000-223
D3152-2 REPLACES PREMIER P/N B30-23000-224
2. MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF DART SPEC. M2024T3S.063)
3. FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5. ALL DIMENSIONS ARE IN INCHES
6. BREAK ALL SHARP EDGES 0.005 TO 0.010
7. MACHINE PER DWG FILE "D3152-B2.DWG"

EB 5/10

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